

Date: Thursday, 3/2/2006 11:39:59 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: DOUBLER ASSEMBLY
<b>Job Number</b>	: 26044		
<b>Estimate Number</b>	: 10294		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D3220041
<b>This Issue</b>	: 3/2/2006	<b>S.O. No.</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3220 REV A1
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 24956B	<b>Drawing Revision</b>	: A1
	<b>Type</b>	<b>Material</b>	: N/A
	: MACHINED PARTS	<b>Due Date</b>	: 3/9/2006
<b>Written By</b>	: <u>SEE COMMENT BELOW</u>	<b>Qty:</b>	9.1 Um: Each
<b>Checked &amp; Approved By</b>	: <u>SEE ABOVE USER &amp; DATE</u>		
<b>Comment</b>	: Est Rev:A New Issue 05-11-06 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S050	2024-T3 .050 sheet
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**Comment:** Qty.: 0.7266 sf(s)/Unit Total : 0.7266 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick  
 (M2024T3S.050  
 Identify for D3220-1  
 Batch: \_\_\_\_\_

2.0	SHEAR	SHEAR
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*see attached*

**Comment:** Cut blank: 14.250" x 7.000" grain along 14.250"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine D3220-1 as per Folio FA362 and Dwg D3220Stack of 5Identify as D3220-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 11:39:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 26044

Part Number: D3220041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-C'sink D3220-1 as per Dwg D3220

SAD

06:03:02

9

7.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-02

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

06:03:02

9

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06-03-02

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

8 MS20426AD3-4

Rivet

M1578C

11.0

MS21059L4

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21059L4

Nutplate

M19522

SAD 06:02:02

9

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3220-041 doubler as per Dwg D3220

SAD

06:03:02

9

13.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-07

Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 11:39:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 26044

Part Number: D3220041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST93

*Handwritten signature and date: 4/3/06*

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Handwritten signature and date: 06/03/08*

Job Completion



*Handwritten signature and date: 06-03-08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:08 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER ASSEMBLY
<b>Job Number</b> : 25552	
<b>Estimate Number</b> : 10295	
<b>P.O. Number</b> :	<b>Part Number</b> : D3220042
<b>This Issue</b> : 1/18/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3220 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 24956C	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 2/5/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A New Issue 05-11-06 JLM	

Additional Product

Job Number:



REFERENCE ONLY

Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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**Comment:** Qty.: 0.7266 sf(s)/Unit Total : 7.2660 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick  
 (M2024T3S.050  
 Identify for D3220-2  
 Batch: M19053

*ml* 06/02/28 10

2.0	SHEAR	SHEAR
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**Comment:** Cut blank: 14.250" x 7.000" grain along 14.250"

*ml* 06/02/28 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine D3220-2 as per Folio FA362 and Dwg D3220 Stack of 5  
 identify as D3220-2

*ml* 06/02/28 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml* 06/02/28 10

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

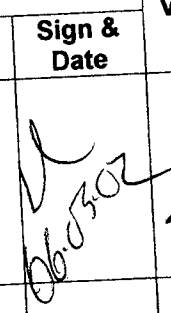
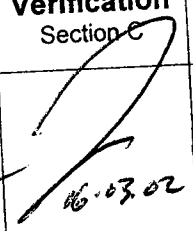
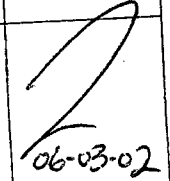
*MB* 06/02/28 10

WORK ORDER CHANGES

N/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng			
06-03-02	6	9 parts C'sunk on wrong Side. Part is <del>now A</del> now A -1		create A w/o for 03220 - 041 Qty of 9	 06-03-02	 06-03-02	 06-03-02

REFERENCE ONLY

NOTE: Date & initial all entries